

Work Order ID 52215

September 21, 2009 7:16:22 AM



Page 1

Item ID: D2576-3

Accept



Setup Start



Revision ID: G

Stop



Item Name: Step (maching detail)

Start Date: 9/21/09 Start Qty: 50.00



Cust Item ID:

Required Date: 9/25/09 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

[Handwritten signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2576

Rev G

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

HAAS 111- Machine as per Folio FA332 and Dwg D2576:12- Deburr

SL 09/09/22

47 3

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SL 09/09/21

47 3

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SL 09/09/21

47 3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D2576-3 PAR #: _____ Fault Category: Prod. Machined Parts NCR: Yes No DQA: _____ Date: 0909.25
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: 0909.25

| NCR: <u>52215</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------------|--|--------------------------------------|---|------------------------------|---------------------------------------|--------------------------------------|--------------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| <u>09/09/21</u> | <u>100</u> | <u>- 3 parts lifted while machining floor thickness of .125\pm.010 varies from .095 to .105</u> <u>R.C: Tooling.</u> | <u>[Signature]</u> <u>1051142</u> | <u>- Scrap & destroy Qty 3</u> <u>- modified tooling to prevent parts from lifting</u> | <u>SK</u> <u>09/09/21</u> | <u>[Signature]</u> <u>09/09/21</u> | <u>[Signature]</u> <u>1051142</u> | <u>[Signature]</u> <u>1051142</u> |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 52215

September 21, 2009 7:16:23 AM



Page 2

Item ID: D2576-3

Accept



Setup Start



Revision ID: G

Stop



Item Name: Step (maching detail)

Start Date: 9/21/09 Start Qty: 50.00



Cust Item ID:

Required Date: 9/25/09 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location:

EAC

0.00



Packaging

Memo

0.00

BARCLAY

Packaging

9/21/09 (4)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/22 HF

MF
09-09-21

Picklist Print

September 21, 2009 7:16:22 AM

Page 1

Work Order ID: 52215

Parent Item: D2576-3RevG

Parent Item Name: Step (maching detail)

Comments:

Start Date: 9/21/09

Required Date: 9/25/09

Start Qty: 50.00

Required Qty: 50.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2576-1RevG | | Manufactured | No | | | 100 | Each | 0.0000 | 50.0000 | | | |



Step (casting detail)



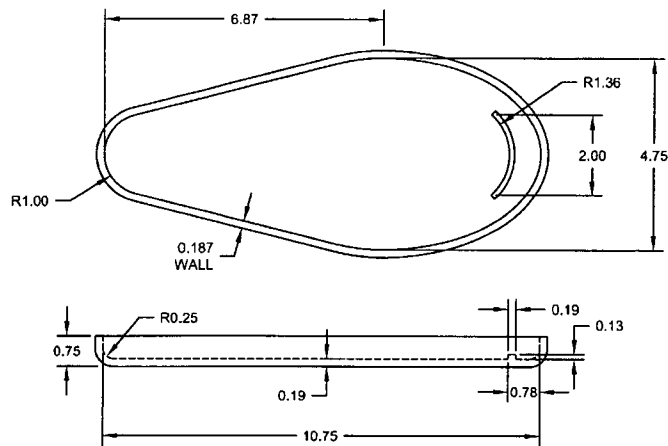
51524

ME 09-09-21

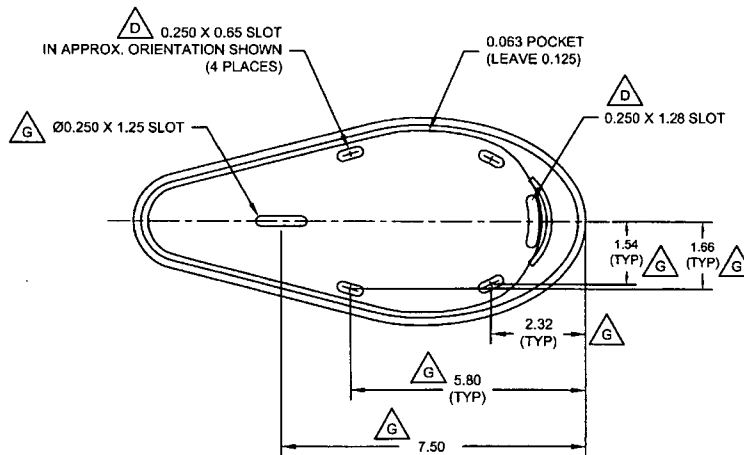
| | | | |
|-----------------------------------|--|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 32215 |
| Description: Step | | Part Number: | D2576-3 |
| Inspection Dwg: D2576 Rev: G | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]



D2576-1 CASTING



D2576-3 MACHINING DETAIL
(MAKE FROM D2576-1)

NOTES:

- 1) MATERIAL: CAST ALUMINUM ALLOY A-535.2
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.025 TO 0.050 MAX
- 6) IDENTIFICATION: NONE

W/O
52215

RELEASED

07.08.29

| REV. | DESCRIPTION | BY | DATE |
|------------|--|----|----------|
| G | - CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM | MB | 07.08.15 |
| F | 7.05 WAS 6.61 | PH | 07.04.17 |
| E | CHANGE 0.50 HOLE LOCATION AND ADD NOTE | RF | 99.09.07 |
| D | CHANGE SLOT SIZE AND LOCATION (TSR A1069) | CP | 99.08.18 |
| C | ADD POCKETS AND SLOTS FOR WELDING | DS | 98.08.18 |
| B | REMOVE POCKETS, ADD HOLE | DS | 96.11.28 |
| A | NEW ISSUE | DS | 96.09.18 |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 07.08.15 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. G
D2576 SHEET 1 OF 1
TITLE SCALE
STEP 1:3

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